

Work Order ID 66498

February 17, 2011 7:21:05 AM



Page 1

Item ID: D4035-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lid Rib Assembly, Fwd (350 Basket)

Start Date: 2/17/11 Start Qty: 2.00



Cust Item ID:

Required Date: 2/23/11 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 11/02/17 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4035	A
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100 Weld per dwg A/R S.S. rod Batch: 1114679 0.00



Large Fab

Memo

0.00

Large Fab

1- Cut D4035-1 as per dwg D4035

2- Drill as per dwg D4035 using DT9562

3- remove identification marks and deburr

4- Weld bushing in rib as per dwg D4035

SAP 11-02-22

② 11.02.22

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

11.02.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66498

February 17, 2011 7:21:05 AM

Page 2

Item ID: D4035-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Lid Rib Assembly, Fwd (350 Basket)

Start Date: 2/17/11

Start Qty: 2.00

Cust Item ID:

Required Date: 2/23/11

Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

Siu 02/22



QC

Memo

0.00

Quality Control

(72)

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Basket cell

Memo

0.00

Packaging

11-02-22 (2x)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/23

MF 11-02-22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 17, 2011 7:21:04 AM

Page 1

Work Order ID: 66498

Parent Item: D4035-041

Parent Item Name: Lid Rib Assembly, Fwd (350 Basket)



Start Date: 2/17/11

Required Date: 2/23/11

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC
per dwg revA 10.03.15 verified by:EC
IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D2327-3  Spacer Bushing		Manufactured	No.			100	Each	9.0000	1	2			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>WA</div> <div>9</div> <div></div> </div>													
<div> <div>58974</div> <div>1</div> <div></div> </div>													
<div> <div>64920</div> <div>8</div> <div></div> </div>													
✓ M304TS0.750W.049  304 SQ Tube .75x.75x.049W		Purchased	No			100	f	258.6957	1.75	3.684211			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>MAT</div> <div>223.9393209</div> <div></div> </div>													
<div> <div>113763</div> <div>0</div> <div></div> </div>													
<div> <div>114323</div> <div>8.15031894</div> <div></div> </div>													
<div> <div>114677</div> <div>0.00001</div> <div></div> </div>													
<div> <div>114835</div> <div>0.000039</div> <div></div> </div>													
<div> <div>116319</div> <div>17.6181</div> <div></div> </div>													
<div> <div>116509</div> <div>19.3317</div> <div></div> </div>													
<div> <div>116719</div> <div>6.102353</div> <div></div> </div>													
<div> <div>116788</div> <div>172.7368</div> <div></div> </div>													
<div> <div>MAT017</div> <div>3.68448E-05</div> <div></div> </div>													
<div> <div>114298</div> <div>3.6845E-05</div> <div></div> </div>													
<div> <div>WA</div> <div>34.7563</div> <div></div> </div>													
<div> <div>114992</div> <div>8.8798</div> <div></div> </div>													
<div> <div>115260</div> <div>25.8765</div> <div></div> </div>													

B66087 (2) 11/02/22

SAD 11-02-22

3.6842

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

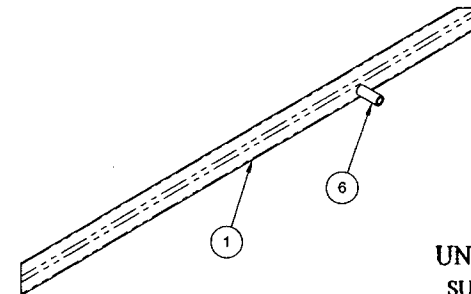
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

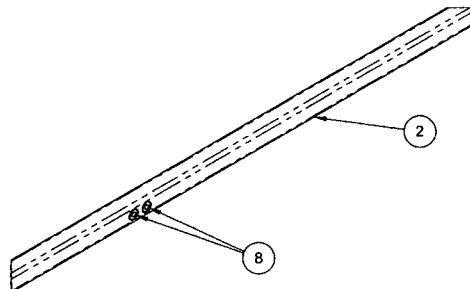
NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X				D4035-041	LID RIB ASSY, FWD
		X			D4035-043	LID RIB ASSY, AFT
			X		D4035-045	LID RIB ASSY, FWD (LIGHT)
				X	D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7			1		D2953-175	SPACER
8		2			D4021-9	BUSHING

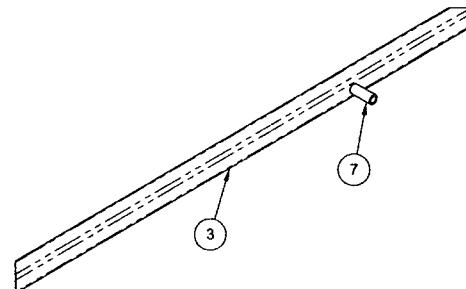


D4035-041 BASKET LID RIB ASSY, FWD

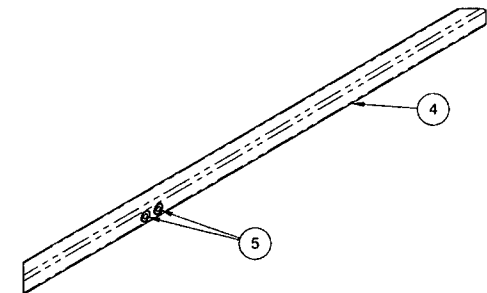
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WORK ORDER
NO. 66498
CZ110217



D4035-043 BASKET LID RIB ASSY, AFT



D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)

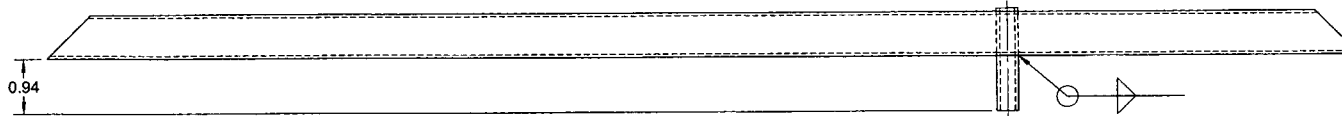


D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

RELEASED
2010-03-12
AW

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID RIB ASSY	NTS
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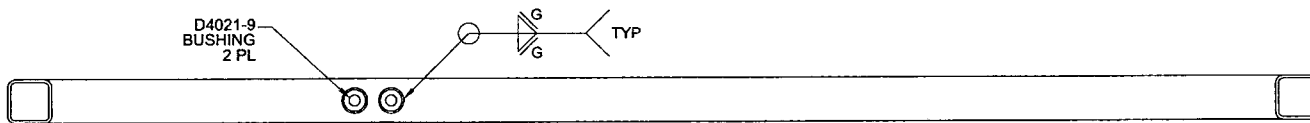
D4035-1
RIB

D2327-3
SPACER BUSHING

D4035-041 BASKET LID RIB ASSY, FWD



D4035-3
RIB



D4021-9
BUSHING
2 PL

TYP

D4035-043 BASKET LID RIB ASSY, AFT

RELEASED
2010-03-12
WDO

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.83 lbs
 - 8) WELDING: PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 2 OF 5
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8 7 6 5 4 3 2 1

D

C

B

A

D

C

B

A

D4035-5
RIB

D2953-175
SPACER

0.94

D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)

D4035-7
RIB

D4035-11
BUSHING
2 PL

G
G
TYP

D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

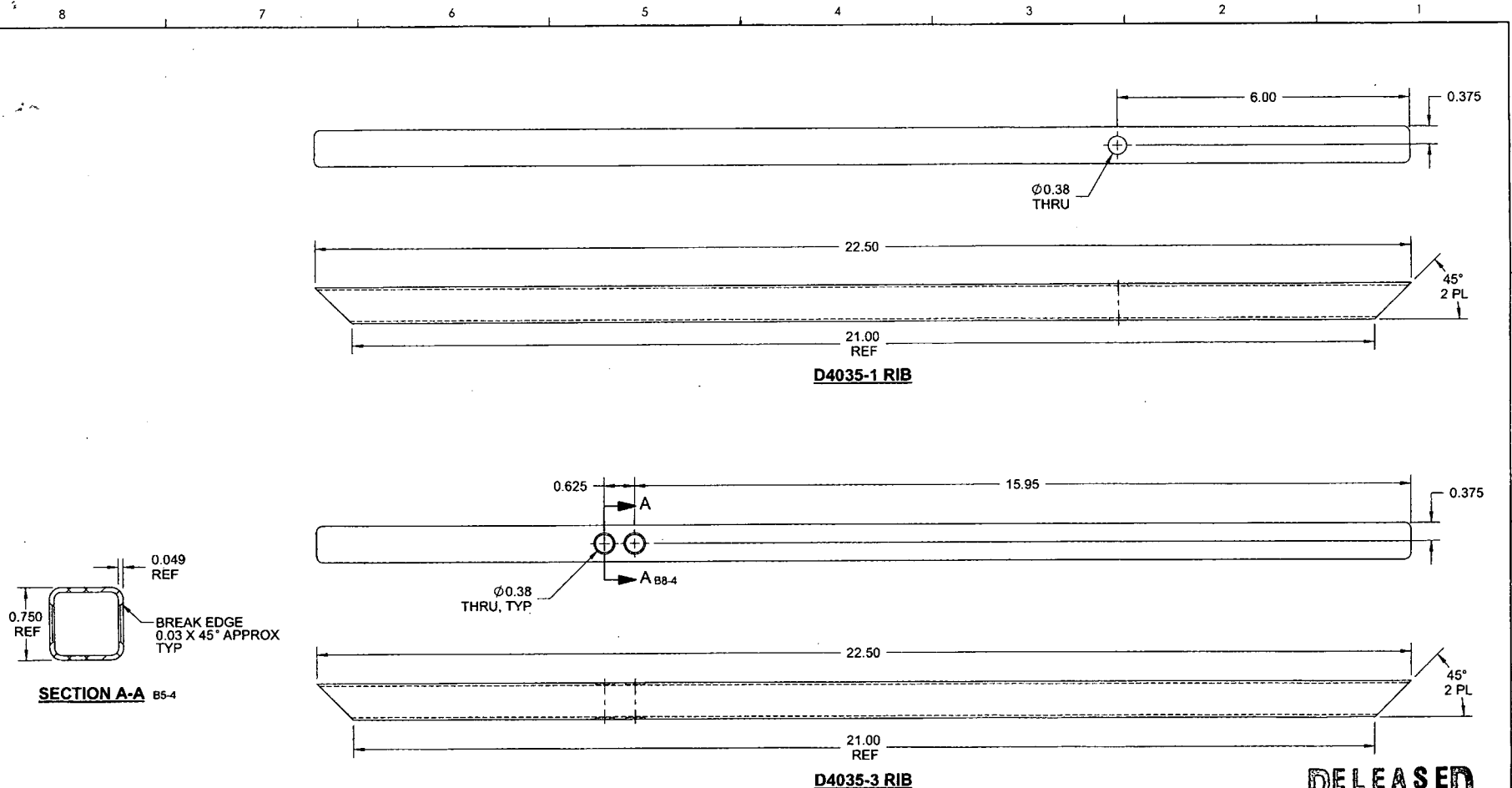
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WORK ORDER
NO. 66498

RELEASED
2010-03-12
140

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.34 lbs
 - 8) WELDING: PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID RIB ASSY	NTS
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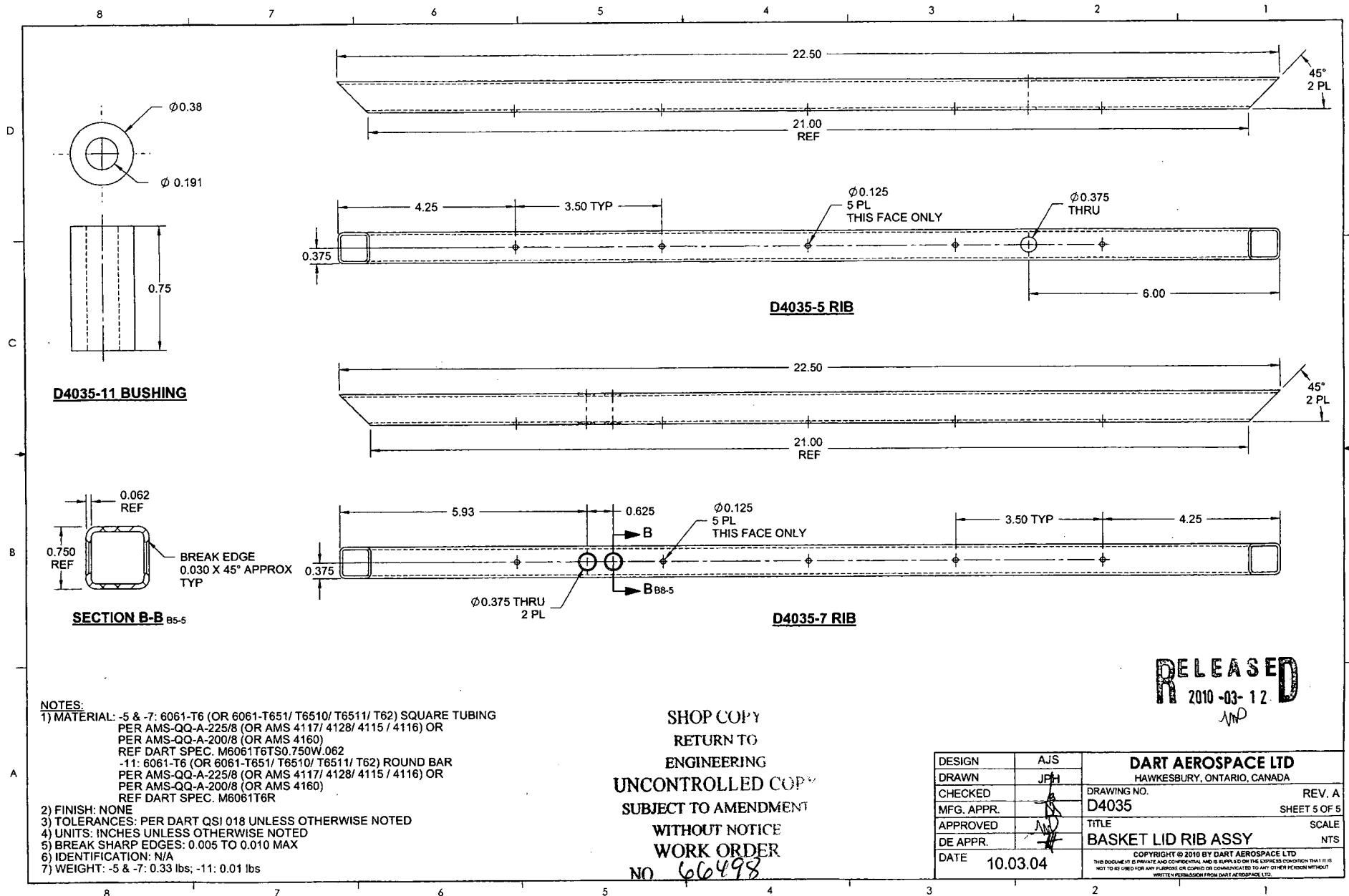


RELEASED
2010-03-12

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
PER ASTM A554/A269 MILL FINISH
REF DART SPEC. M304TS0.750W.049
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.80 lbs

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NO. 66498

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH	DRAWING NO. D4035	REV. A SHEET 4 OF 5
CHECKED		TITLE BASKET LID RIB ASSY	SCALE NTS
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APPROVED		DATE 10.03.04	
DE APPR.			



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